



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3699-042
Job Sheet 168980



Part No: D3699-042

Job Qty: 4 ea

Part Name: Support Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/28/17

Job Tracking No:

Due Date: 1/5/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A 08-04-25 new issue DD verified by:ec IPP Rev:B 08-07-14 revA as per dwg DD
verified by:ec IPP REV:C 17.12.05 ADD MISSING INFO THAT WAS IN INTUITIVE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/4/18	0.00	0.00	Start Up Waterjet		SC
100	Waterjet	4 pcs		1/4/18	0.00	0.70	Waterjet1		SC
110	QC	4 pcs		1/4/18	0.00	0.00	QC2		SC DAS
120	QC	4 pcs		1/4/18	0.00	0.00	QC8		SC 38
130	Brake NC	4 pcs		1/4/18	0.10	0.25	Brake NC 1		SC DAS 38
140	QC	4 pcs		1/4/18	0.00	0.00	QC5		SC 38
150	Small Fab	4 pcs		1/4/18	0.00	0.10	Small Fab		DA 38 9-80
160	QC	4 pcs		1/4/18	0.00	0.00	QC5		SC 38
170	HandFinish	4 pcs		1/4/18	0.00	0.23	HandFinish1		2018/01/09/28
180	Powdercoat	4 pcs		1/4/18	0.00	0.29	Powdercoat4		BE 18-01-9
190	QC	4 pcs		1/4/18	0.00	0.00	QC3		SC
200	Packaging	4 pcs		1/4/18	0.00	0.00	Packaging1		SC
210	Small Fab	4 pcs		1/5/18	0.00	0.10	Small Fab		SC
220	QC	4 pcs		1/5/18	0.00	0.00	QC5		PD 18-01-11
230	Packaging	4 pcs		1/5/18	0.00	0.00	Packaging3	57506	AT 18-01-11
240	QC21-SA	4 Ea		1/5/18	0.00	0.00	QC21		DAS

Part Op 100 - 1-Cut as per Dwg D3699 Dwg Rev: A Prog Rev: A ***grain direction along 9.00" *** 2- Debur
Descriptions: necessary

150 - 1-Counter sink holes and deburr as per dwg D3699 2- Bend as per dwg

180 - START TIME: 3:25 OVEN TEMPERATURE: 320° FINISH TIME: 3:55

210 - Assemble as per dwg D3699

M 135418

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.050	2	35	0	0
210-Small Fab	MS20426AD3-3 <u>5018535</u>	8	6,814	0	0
	MS21059L3 <u>FM137659</u>	4	48	0	0
	<u>130942</u>				

Part Specifications

Specifications could not be found.

DART
AEROSPACE

S023210



Support Assembly

PART NO:
Revision:
Operation:
Change No:

D3699 - 042

Start up Operation

Mfg Date: 12/15/17
Job No: 168980

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DART AEROSPACE LTD		Work Order:	168930
Description: Support, RH		Part Number:	D3699-2
Inspection Dwg: D3699 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	Ø0,099	1		VDC-02	
Ø0.180	+0.005/-0.001	Ø0,180	1			
Ø0.238	+0.005/-0.001	Ø0,240	1			
Ø1.525	+0.012/-0.001	Ø1,525	1			
0.36	+/-0.030	0,367	1			
0.62	+/-0.030	0,628	1			
0.96	+/-0.030	0,965	1			
2.21	+/-0.030	2,218	1			
4.12	+/-0.030	4,127	1			
8.95	+/-0.030	8,956	1			
1.925	+/-0.010	1,927	1			
8.61	+/-0.030	8,613	1			
2.62	+/-0.030	2,628	1			
0.344	+/-0.010	0,345	1			
0.688	+/-0.010	0,689	1			
0.64	+/-0.030	0,645	1			
2.66	+/-0.030	2,668	1			
5.75	+/-0.030	5,747	1			
6.41	+/-0.030	6,415	1			
0.300	+/-0.010	0,302	1			
0.923	+/-0.010	0,925	1			
0.050	+/-0.010	0,048	1			

Measured by:	SC	Audited by:	38	Prototype Approval:	N/A
Date:	17/12/15	Date:	DEC 18 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	DD



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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D3699-042 Revision: Support Assembly														
240	QC21-SA	S023210	168980	4 Ea	0	S023210	ST506	Bin	Stock	12/15/2017	Issue Container			
Operation Totals:		1		4	0									
Part Totals:		1		4	0									
Part Number: M6061T6S.050 Revision: 6061-T6 .050 Sheet														
100	Receive sf	S023207	168980	0 sf	0	M136942	MAT021		Stock	12/15/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		4	0									

Plex 1/12/2018 2:21 PM Dart.Lajeunesse.Marie